

**\*86645\***

July-06-12 11:10:57 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*5\***

**\*5\***

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

Date:

**Insp.  
Stamp**

Rev B

0.00

**\*100\***

## BAND SAW

## Bandsaw

## Memo

## Jeaspa Bandsaw

1- Cut blank: 22.00" as per Dwg D3304

0.00

0.00

110

**\*110\***

### CONVENTIONAL LATHE

Lathe Conv

## Memo

### Conventional Lathe

1- Cut blank: 22.00" as per Dwg D33042- Turn as per Dwg D33043- Deburr

0.00

0.00

120

**\*120\***

QC

## Memo

### Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86645

**\*86645\***

Page 2

July-06-12 11:10:57 AM

Item ID: D3304-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Tube Assembly  
 Start Date: 7/06/12 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 7/06/12 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
<b>*130*</b>									
QC	Memo	0.00				5	0		
Quality Control									
140		0.00							
<b>*140*</b>									
Small Fab									
Small Fab	Memo	0.00				4	0		
	1- Form as per Dwg D3304 Ensure that bend radius does not fall into straight section using DT8756.2- Drill as per Dwg D3304 using drill Jig D3304-T13- Cut tube to length as per Dwg D33044- Debur								
150	QC5- Inspect part completeness to step on W/O	0.00							
<b>*150*</b>									
QC	Memo	0.00				4			
Quality Control									

FF  
12-09-12

PTO

SMB  
12-9-13

DAS  
16  
17/09/16

W/O: 86045		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3304-043 PAR #: \_\_\_\_\_ Fault Category: San Tab NCR: (Yes No) DQA: AK Date: 12/10/03  
 Resolution: \_\_\_\_\_ Disposition: Scrap QA: N/C Closed Date: 12/10/04

NCR: 12-1856		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12-09-12	140	<del>Human error</del> 1 part is scrap because bend is out of toleran  d.c. Process <del>Human error</del> misread instruction of bda when Drill 3.4 mm	DAS 16 2-03 ASZALZ 12/09/13	map + destroy  #1143.60	FF 12-09-12	SM 12/09/12	DAS 15 2-03 ASZALZ 17/09/13	DAS 15 2-03 12/09/13

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86645

\*86645\*

Page 4

July-06-12 11:10:57 AM

Item ID: D3304-043 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Tube Assembly  
 Start Date: 7/06/12 Start Qty: 5.00 \*5\* Cust Item ID:  
 Required Date: 7/06/12 Req'd Qty: 5.00 \*5\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* Powdercoat Powder Coating 121279	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 Memo START TIME: 2:20 FINISH TIME: 1:50	0.00 0.00				4X			M-L 12/04/26
200 *200* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				4		129-26	(DAS 34)
210 *210* Small Fab Small Fab	Small Fab Memo Assemble lanyard and pip pin as per Dwg D3304Identify as D3304-043	0.00 0.00				4		12-09-27	FF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 86645

**\*86645\***

Page 5

July-06-12 11:10:57 AM

Item ID: D3304-043 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Tube Assembly  
 Start Date: 7/06/12 Start Qty: 5.00 **\*5\*** Cust Item ID:  
 Required Date: 7/06/12 Req'd Qty: 5.00 **\*5\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220 <b>*220*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	Smb 12-9-27	DAS 16 12/9/28		4			
--	---	--------------	----------------	----------------------	--	---	--	--	--

230 <b>*230*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>ST186</u>  Memo	0.00 0.00				4			12/09/28 JB
---	--	--------------	--	--	--	---	--	--	-------------

240 <b>*240*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							MLJ 12-6-01 MLJ 12-09-28
--	---	--------------	--	--	--	--	--	--	-----------------------------

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July-06-12 11:10:56 AM

Page 1

Work Order ID: 86645

Parent Item: D3304-043

Parent Item Name: Tube Assembly

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: D 04.11.26 Revised Step 7 KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
BLBS-0016 PIP PIN		Purchased	No			210	Each	19.0000	1	5			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST283		9							
				113565		9				3			
				ST284		10							
				122190		10				1			
CBL-1240 Cable		Purchased	No			100	f	776.2792	1.0416	5.208			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		776.279191							
				113565		3.911789							
				119021		259.334002				4.1664			
				119690		13.0334							
				122190		500							
CBL-460 Loop Sleeve		Purchased	No			210	Each	578.0000	2	10			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		578							
				121574		578				8			
D3304-7 Bracket		Manufactured	No			210	Each	4.0000	1	5			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA022		4							
				44398		4				2.4			

(4) FF 12-09-27

(4) FF 12-09-27

(4) FF 12-09-27

12-09-25  
JBL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July-06-12 11:10:57 AM

Page 2

Work Order ID: 86645

Parent Item: D3304-043

Parent Item Name: Tube Assembly

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 5.00

Required Qty: 5.00

M304TR0.875W.065

Purchased

No

160

f

47.0000

1.8542

9.7589474

304 round tube .875 x .065w

Location

Loc Qty

Loc Code

MAT017

47

110680

7

121317

40

M122541

10.0 ~~10~~ 12-08-07

July-06-12 11:10:57 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material									
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

### FAULT CATEGORY

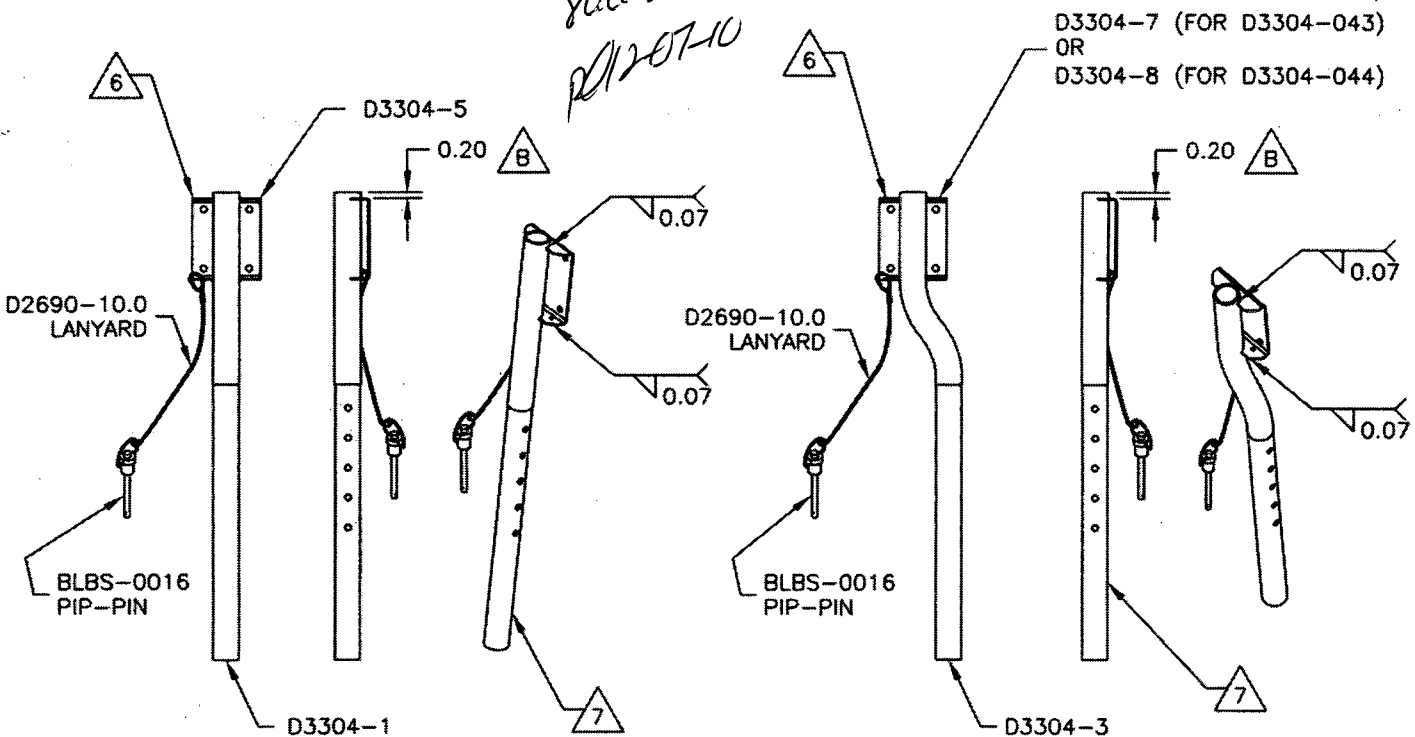
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions  <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
---	---	--





**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DESIGN	RF	DRAWN BY	RF	DRAWING NO.	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	D3304	SHEET 1 OF 4
DATE	05.07.15	TITLE	TUBE ASSEMBLY	SCALE	1:6
A	04.08.18	NEW ISSUE			
B	05.07.15	UPDATE DIMENSIONS; ADD D3304-7/-8			



**D3304-041 TUBE ASSEMBLY**

**D3304-044 TUBE ASSEMBLY (SHOWN)  
D3304-043 OPPOSITE**

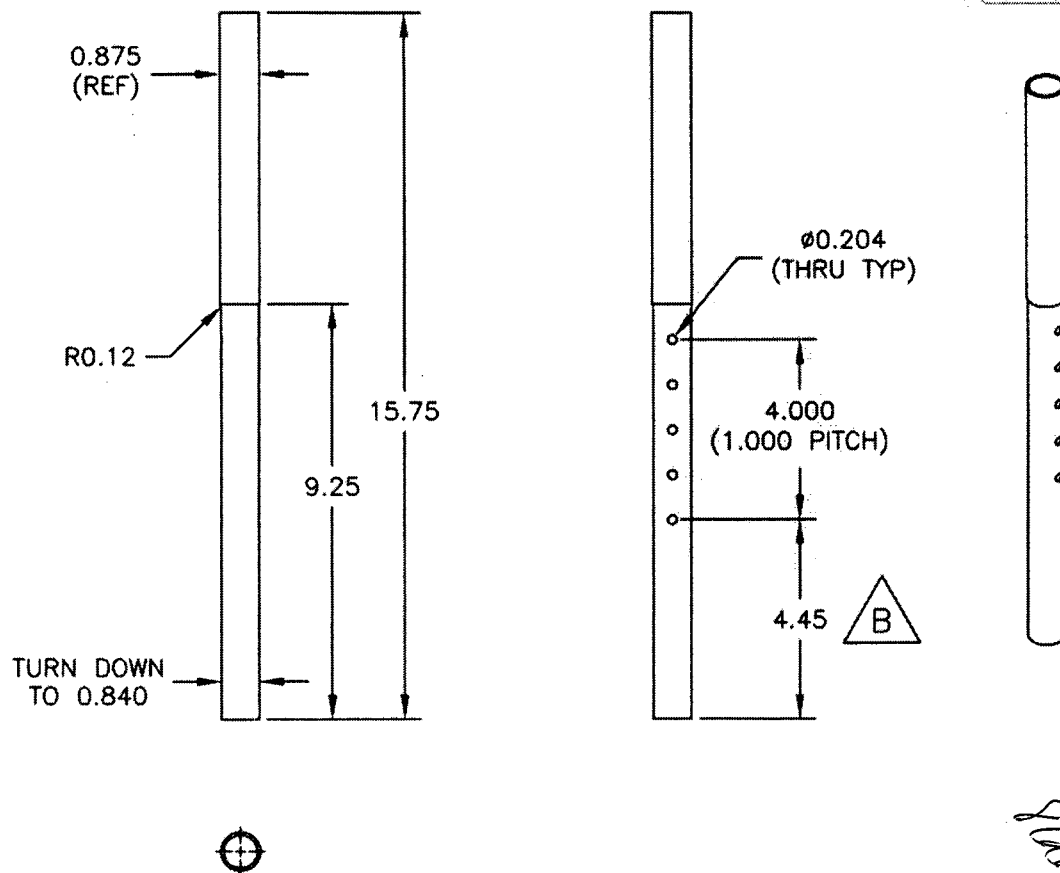
**D3304-041/-043/-044 NOTES:**

- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

RELEASED  
05-08-11

**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 2 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

**RELEASED**  
05.08.11 *[Signature]***D3304-1 TUBE****D3304-1 NOTES:**

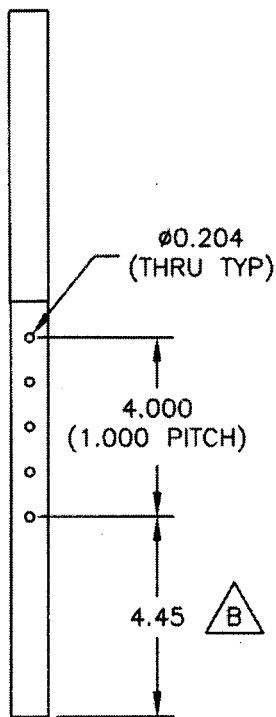
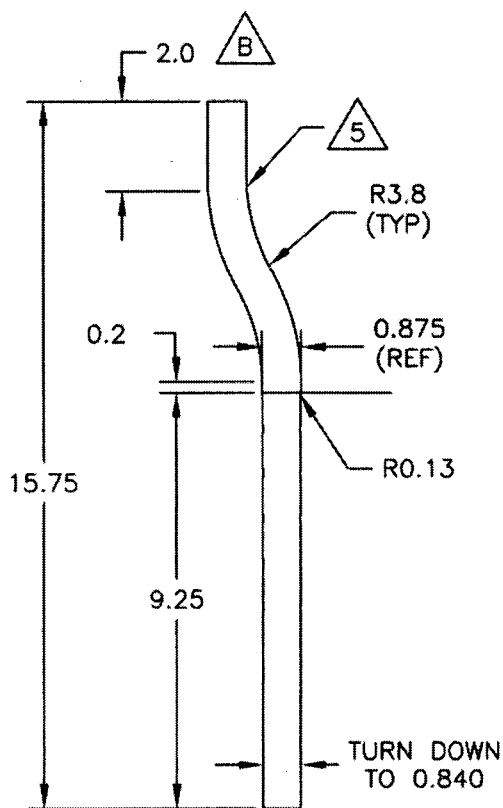
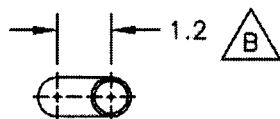
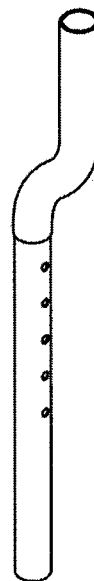
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE  $\phi 0.875 \times 0.065$  WALL  
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 3 OF 4
DATE 05.07.15		TITLE TUBE ASSEMBLY	SCALE 1:4

**RELEASED**  
05-08-11 *[Signature]***D3304-3 TUBE****D3304-3 NOTES:**

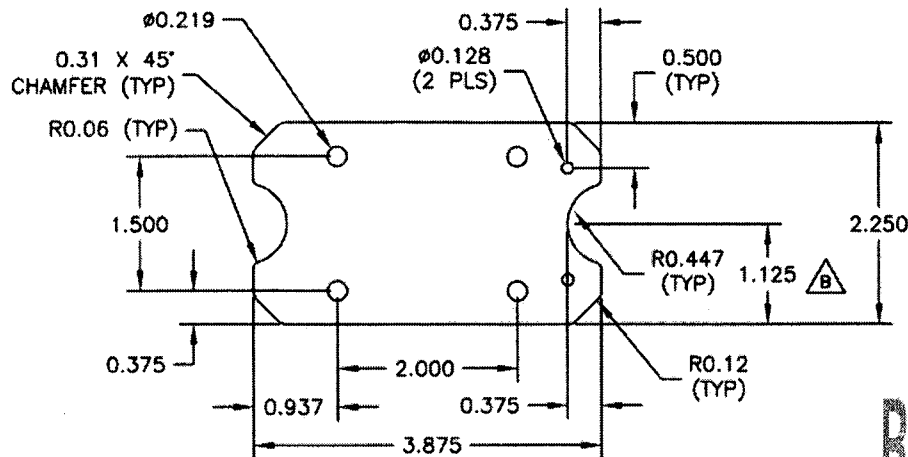
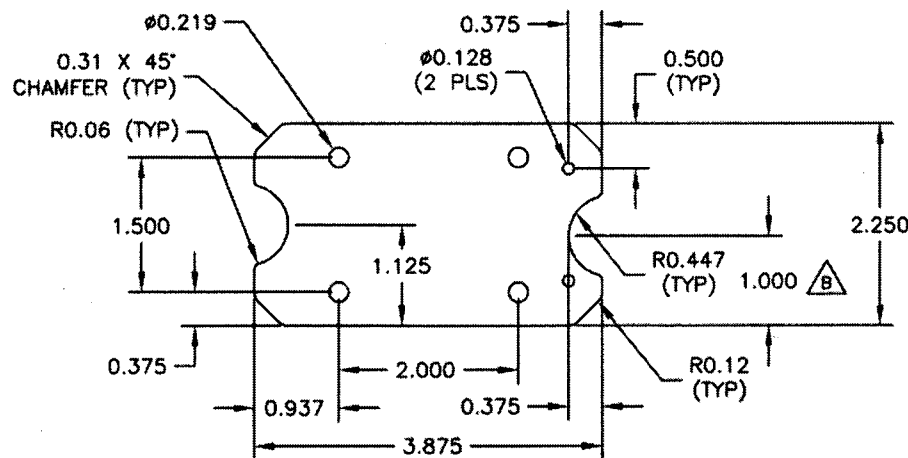
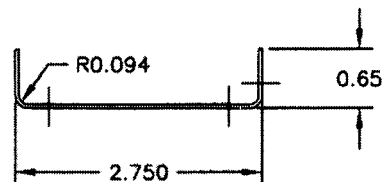
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE  $\phi 0.875 \times 0.065$  WALL  
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

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**DART**

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3304	REV. B SHEET 4 OF 4
DATE 05.07.15	TITLE TUBE ASSEMBLY		SCALE 1:2

**D3304-5 FLAT PATTERN****D3304-7/-8 FLAT PATTERN****D3304-5/-7 BRACKET  
D3304-8 OPPOSITE****NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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